

This listing of claims will replace all prior versions, and listings, of claims in the application:

Amendments to the Claims:

Please amend the claims as follows:

1-13. (cancelled)

14. (currently amended) A punching machine, comprising:

a body frame having a table (33, 35), the table supporting a workpiece (W) to be worked;

a first positioning device (53) mounted on the table (33), the first positioning device (53) having a first drive motor (49) and a first carriage (55) driven by the first drive motor (49), the first positioning device (53) positioning the workpiece (W) in a first direction (X) by the first drive motor (49) through the first carriage (55), so that the first positioning device (53) does not position the workpiece (W) in a second direction (Y) perpendicular to the first direction (X);

a second positioning device (69) mounted on the table (35), the second positioning device (69) having a second drive motor (65) and a second carriage (71) driven by the second drive motor (65), the second positioning device (69) positioning the workpiece (W) in the first direction (X) by the second drive motor (65) through the second carriage (71), so that the second positioning device (69) does not position the workpiece (W) in the second direction (Y) perpendicular to the first direction (X) wherein the second carriage (71) is transferred by the second drive motor (65) independently from the first carriage (55) driven by the first

drive motor (49) thereby the first carriage (55) and the second carriage (71) are independently transferred from each other in the first direction (X); and

a working head (8, 9, 11, 25) comprising a die block (9) having a plurality of dies (D); a punch block (11) having a plurality of punches (P); and a ram drive unit (25) wherein the die block (9), punch block (11) and the ram drive unit (25) are united in a united working head (8, 9, 11, 25), the united working head (8, 9, 11, 25) being slidably mounted in the body frame so as to be unitedly positioned in the second direction (Y) to punch the workpiece (W), thereby punching the workpiece (W) along the second direction (Y),

wherein the first positioning device (53) and the second positioning device (69) are arranged in series in the first direction (X), thereby the workpiece (W) is transferred only in the first direction (X) by one of the first positioning device (53) and the second positioning device (69); and the workpiece (W) is not transferred in the second direction (Y); and

wherein the first positioning device (53) and the second positioning device (69) are constructed in a manner such that the first positioning device (53) and the second positioning device (69) may alternately transfer the workpiece (W) in the first direction (X) during punching operation by alternate drives from the first drive motor (49) and the second drive motor (65), so that the workpiece (W) can be advancingly shifted in the first direction (X) by alternative operations of the first positioning device (53) and the second positioning device (69), and that the workpiece (W) can be reversingly shifted in the first direction (X) by the alternative operations of the first positioning device (53) and the second positioning device (69);

wherein the first positioning device (53) includes a first clamp (53C, 53D) to clamp a first margin of the workpiece (W) in the first direction;

wherein the first positioning device (53) further includes a second clamp (53A, 53B) to clamp a second margin opposite to the first margin of the workpiece (W) wherein the second clamp (53A, 53B) is fixedly mounted to the first positioning device (53) and wherein the second clamp (53A, 53B) is not moved in the second direction (Y);

wherein the first positioning device (53) still further includes a first approaching motor (83) to approach the first clamp (53C, 53D) to the second clamp (53A, 53B);

wherein the first clamp (53C, 53D) is movably mounted to the first positioning device (53) in the second direction (Y) so that the first clamp (53C, 53D) can be moved to approach the second clamp (53A, 53B) in the second direction (Y) thereby enabling the clamping of the workpiece (W) even though a size of the workpiece (W) in the second direction varies during a punching operation;

wherein the second positioning device (69) includes a third clamp (69C, 69D) to clamp the first margin of the workpiece (W) in the first direction;

wherein the second positioning device (69) further includes a fourth clamp (69A, 69B) to clamp the second margin opposite to the first margin of the workpiece (W) wherein the fourth clamp (69A, 69B) is fixedly mounted to the second positioning device (69) and wherein the fourth clamp (69A, 69B) is not moved in the second direction (Y);

wherein the second positioning device (69) still further includes a second approaching motor (83) to approach the third clamp (69C, 69D) to the fourth clamp (69A, 69B); and

wherein the third clamp (69C, 69D) is movably mounted to the second positioning device (69) in the second direction (Y) so that the third clamp (69C, 69D) can be moved to approach to the fourth clamp (69A, 69B) in the second direction (Y) thereby enabling the

clamping of the workpiece (W) even though the size of the workpiece (W) in the second direction varies during punching operation.

15-16. (cancelled)